

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015987**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Che Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #3

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13AE, weld No. FB3126-001-050. The welder is identified as #044824. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW in the 3G position for the OBG Segment 13AE, weld No. FB3110-001-049. The welder is identified as #206623. ZPMC QC is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW in the 2F position for the OBG Segment 13AW, weld No.FB3173-001-027/028. The welder is identified as #062708. ZPMC QC is identified as Mr. Zhu Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

Bay #2

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This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13AW, weld No.EB3047-001-001. The welder is identified as #045240. ZPMC QC is identified as Mr. Zhu Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2F position for the OBG Segment 13AW, weld No.EB3031-001-003/004. The welder is identified as #045203. ZPMC QC is identified as Mr. Zhu Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2132-3.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Floor beam "T" weld joints. The notification number is identified as 06193.

The welds designation reviewed are as follows:

FB3123-001-044,045,047,051,057,060

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% of weld for OBG floor beam. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians. The notification number is identified as 06193.

The weld designations reviewed is as follows

FB3229-001-001~006

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% of weld for OBG floor beam. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians. The notification number is identified as 06189.

The weld designations reviewed is as follows

FB3215-001-001~006

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% of weld for OBG floor beam. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians. The notification number is identified as 06197.

The weld designations reviewed is as follows

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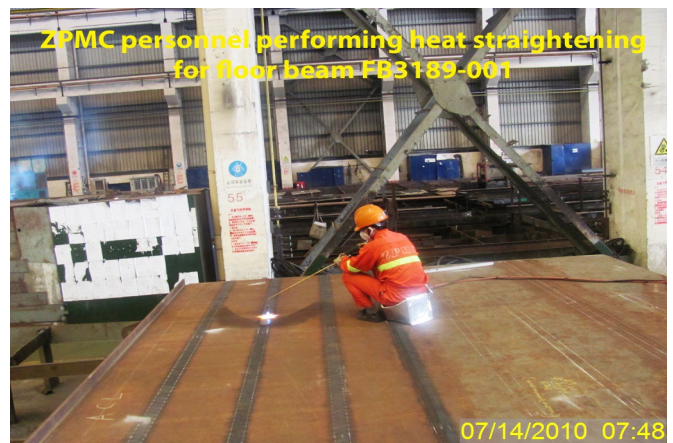
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FB3146-001-010

FB3109-001-064,069,083,090,097,104,088,089,095,096,102,103,062,063,067,068,072,073,081,082,074

During random visual inspection the QA inspector observed that the ZPMC MT technician were performing Magnetic Particle Testing on CJP weld joint of traveler rail after heat straightening at bay#2 area. During Magnetic Particle Testing the ZPMC MT technician found total four (4) transverse linear MT indication on weld area. Three indication found on weld joint 20TR1-008 and one indication at 20TR1-004. The QA inspector informed to ABF QA Mr. Chu Ziqing ad ZPMC QC Mr. Chen Xi to make CWR for repair of those welds. For more information see the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer